120

QC2- Inspect parts off machine FAI/FAIB

0.00

120 QC

Memo

Quality Control

									,
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3179	Rev D						Α,	•.	
100	BAND SAW	0.00	De/b. 1	3/08/1	5	ລ	B		
Bandsaw	Memo	0.00	,				-Y		

0.00

DiR|8013/08/16

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE					
												QA Closed:	Da	ate:	
Work Ord	۸.					DISPOSITION				AGAINST D	E	PARTMENT,	/PROCESS		
WORK Ord	۲۱.			•		Rework	٦l		Skid-tube	Crosstube		•	Water Jet	-[Engineering
Part I	Vo.					Scrap	1		Machining	Small Fab	-	Pro	d. Eng. Coor.	-	Quality
						Use-as-is	1 I	1	noforming	Finishing			e/Packaging		Other
NCR I	No.					Work Order Update	1		Large Fab	Composite			Supplier	-	
															
Root						ption of work order update		Initial		tion		Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verification	n	QC Inspector
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Operator				ļ											
Material			•												
Setup	L.							•							
Other			ĺ									į			
Process	<u> </u>														
Supplier	Ш														
Training	匚														
Unapproved			<u> </u>	<u></u>	<u> </u>							:			<u></u>
		···	- 			F	AUL	T CATE	GORY						
Landi	ng (l				General	_	1		_	_	1			7
Bending							<u> </u>	Grain		<u> </u>	_	Ovalized		_	Pressure/Forced
		Centre No	ot Conce	ntric to	O/S	BOM/Route		Hardwa		L		Over/Under	tolerance	_	Temperature/Cure
						Broken/Damaged	\perp	1	on Incomplete	<u></u>	_	Part Incorred		<u>_</u>	Weld
Crushed/Crimped Burrs						Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
	Cuffs					Contamination		Mainte	enance	<u>. </u>		Part Moved			
	Heat Treat Countersin					Countersink	Mislabeled			Positioned Wrong		-			
	Inspection Strip in Tube Cut Too					Cut Too Short	Misread				,	Power Loss/:	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 105536 Page 2 August-08-13 8:58:14 AM D3179-041 Accept *N900040100* Item ID: Setup Start **Revision ID:** Item Name: LITTER TIE DOWN (NON-LOCKING) Start Qty: 2.00 Start Date: 8/08/13 **Cust Item ID:** Required Date: 8/08/13 Req'd Qty: 2.00 Customer: Reference: Run Tooling: Approvals: Process Plan: Date: Date: Stop SPC (Y/N): QC: Date: Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. Qty Work Center ID Description **Run Hours** Code Qty Number Stamp 130 OC8- Inspect parts - second check 0.00 *13()* 113-8-19 QC 0.00 Memo Quality Control Chemical Conversion Coat per QS1005 4.1 140 0.00 *140* HandFinish 0.00 Memo Hand Finishing Inspect Part Finish 150 2x g m/ 13/08/20 0.00 *150*

0.00

Memo

QC

Quality Control

			DQA:	Date:	
NCR:	Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Clo	sed:	Da	ite:		
Work Orde	er:					DISPOSITION			, 	AGAINST DI	PARTM	IENT/PF	ROCESS			
Part N	- . No.					Rework Scrap Use-as-is Work Order Update		1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Rec	Prod. l	Water Jet Eng. Coor. Packaging Supplier		Engineering Quality Other	
Root					Descri	ption of work order update		nitial	Act	tion	Sign	&				_
Cause	l	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Dat	e '	Verificatio	n	QC Inspector	
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Equip/Tooling]	-				
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Landi		1			_	General		1 .		F	٦ .					
[Bending			<u> </u>	Bend		Grain		<u></u>	Ovalize			—	Pressure/Forced	
!		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa		ļ	-{	Inder to	erance	-	Temperature/Cure	
	-	Cracks				Broken/Damaged	\vdash		ion Incomplete	,	Part Inc				Weld	
	Crushed/Crimped				<u> </u>	Burrs	-		ions incomplete/l	Unclear	-1	st/Missir	ng	Ш	Wrong Stock Pulled	
!	Cuffs			Contamination		Mainte			Part Mo							
	Heat Treat				Countersink		Mislabe		<u></u>	4	ned Wro	_				
					<u> </u>	Cut Too Short	_	Misread	d .		Power	Loss/Sur	rge	Ш	Other	_
· • · · · · · · · · · · · · · · · · · ·					<u> </u>	Drill Holes		Offset					<u></u> .			_
, 					`	Drawing	\vdash		Calibration							_
	Turning Sequence				<u>_</u>	Finish	Out of Sequence					_	<u>.</u>		_	_
1	1	lWave/Tw	vist in Tuł	ne -		Folio	1	Outside	Dimensions							

0.00

Small Fab

Small Fab

											DQA:	Date:	
NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: D											 Date:		
Work Orde	٠r٠					DISPOSITION	Ţ		A	GAINST DE	PARTMENT,	PROCESS	
Part No. NCR No. Root Date Step Qty						Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite				mall Fab	Prod Rec/Stor	Engineering Quality Other	
Root					l	ption of work order update		nitial	Action	-	Sign &		
Cause	_L	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Descriptio	n	Date	Verification	QC inspector
Doc/Data													
Equip/Tooling													ļ
Operator				1					1				
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Setup	\Box		·				Ì						
Other													
Process	П												
Supplier													
Training				ŀ							i	-	
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			•			F.	AUL	CATE	GORY				
Landi	ng Ge	ar				General				_			
	Пв	ending				Bend	\Box	Grain			Ovalized		Pressure/Forced
Centre Not Concentric to O/S						BOM/Route	Route Hardware				Over/Under tolerance		Temperature/Cure
Cracks Broken/Damaged							Inspection Incomplete			Part Incorrec	t 🗀	Weld	
,	Crushed/Crimped Burrs							Instruct	ions Incomplete/Unclea	ar 🗔	Part Lost/Mi	ssing	Wrong Stock Pulled

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Contamination Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Part Moved

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cuffs

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Work Orde August-08-13 8		5536		*105	5536*						Page 4
Item ID: Revision ID: Item Name:	D3179-041	DOWN (NON-LOCKIN	(G)	Accept	*N90004	.010	N *	Setup S	tart top	*NS	S1* S2*
Start Date: Required Date: Reference:	8/08/13	Start Qty: 2.00 Req'd Qty: 2.00	*2°	* *	Cust Item ID: Customer:					IV.	17
Approvals:	Process Pla	in:	Date:	Tooling:	Date:	<u> </u>			tart	*NF	₹1*
	QC:	<u> </u>	Date:	SPC (Y/N):	Date:			S	top	*NF	₹2*
Sequence ID/ Work Center II 190 *100* QC Quality Control	D	Operation Description QC5- Inspect part compl	eteness to step on W.	Set Up/ Run Hours /O 0.00 DAS 27 0.00 9-89		ol # Plan Code	Accept Qty	t Reject Qty		Reject Number	Insp. Stamp
200 *200* Packaging Packaging		Identify as per dwg & Ste	ock Location	0.00			2x_			 (]	50 3-7-30
²¹⁰ *21∩* ^{QC}		QC21- Final Inspection -	Work Order Release	e 0.00 0.00					17	19/3	348
Quality Control		Tradition									

\$ 13-08-30

DQA:	Date:	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

NCK. 1	es / NO				WORK ORDER HOR-	COMO	MINIMEL / OF	DAIL	QA Closed:	Date:	i	
Work Orde	F.				DISPOSITION			AGAINST DE	PARTMENT,	/PROCESS		
Part N					Rework Scrap		Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality	
NCR N	0		<u> </u>		Use-as-is Work Order Update	The	Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other	
Root				Descri	ption of work order update	Initia	Ac	ction	Sign &			
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Desc	cription	Date	Verification	QC Inspector	
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quip/Tooling												
Operator		1										
viaterial											•	
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Other					•							
rocess												
iupplier		1										
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Inapproved		1	<u>l. </u>					_		<u> </u>		
						FAULT CA	TEGORY					
Landir	g Gear				General			_	1		1	
1	Bending			<u> </u>	Bend	Grai			Ovalized	<u> </u>	Pressure/Forced	
1	Centre N	ot Conce	ntric to C	D/S	BOM/Route	\vdash	ware		Over/Under	<u> </u>	Temperature/Cure	
	Cracks ,				Broken/Damaged		ection Incomplete	<u></u>	Part Incorre		Weld	
	Crushed/	Crimped		<u> </u>	Burrs	⊢ —∹	uctions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled	
	Cuffs				Contamination .	—	ntenance		Part Moved			
	Heat Tre			<u></u>	Countersink	⊢	beled		Positioned V		7	
	Inspection	•	Tube	<u> </u>	Cut Too Short	Misr			Power Loss/	Surge	Other	
	Ripples in			L	Drill Holes	Offse					· · · · · · · · · · · · · · · · · · ·	
ļ	Torque V	Vaves in E	extrusion	` <u> </u>	Drawing	-	of Calibration					
	Turning 9	Sequence			Finish	Out	of Sequence					
	Wave/Twist in Tube Folio						Outside Dimensions					

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

August-08-13 8:58:14 AM

Work Order ID:

105536

Parent Item:

D3179-041

Parent Item Name:

LITTER TIE DOWN (NON-LOCKING)

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP A1 03.01.09 Added Acid etch end alodine

IPP Rev:B Added Powder Coat 07-07-04 JLM

13-05-24 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measur		Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2372 Quick Release		Manufactured	No			180	Each	19.0000	. 2	4	130	[68].	20
				Location		Loc Qty	Į	Loc Code					
				GA		19					·		
				102	247	8				<u>/</u>			
				860		2							
				978		. 5						/	
				998	10	4				 -	111		
D2444 Pip Pin Assembly		Manufactured	No			180	Each	13.0000	1 	2 	<i>5</i> 53	[88]	20_
				Location		Loc Qty		Loc Code			′ /		
				ST010		13						,	
				101	027	10							
				972		1				9			
				993	70	2							
D6201 "T" Extrusion		Manufactured	No			180	f	29.0146	1.0125	2.13157		·- ·	
				Location		Loc Qty		Loc Code			**************************************		
				MAT028		29.01463153					_	٠	
	٦	•		814	21	0.56863153	•		2.6	35	THER	E 13	
				839	87	16.8					47		•
				896		0.246					1.0	3125	ft
				968	08	11.4			Delpe	 · 13/	STIL 08/18	0125 L LET	5

IPP REV:C AS PER REV D JLM

										DQA:	Date	2:
NCR: Y	es / No)			WORK ORDER NON-O	100	NFORM	AANCE / UPDA	ATE	•		
·										QA Closed:	Date	2:
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIN OIGE					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is]	Therm	oforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	No				Work Order Update]		Large Fab (Composite		Supplier	
Root				Descri	ption of work order update		Initial	Action	n	Sign &		
Cause	Date	Step	Oty		or Non-conformance	Ch	nief Eng	Descript	tion	Date	Verification	QC Inspector
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	Bendir	g			Bend		Grain			Ovalized	L	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route						Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks		Broken/Damaged		Inspecti	on Incomplete	<u></u>	Part Incorred	it L	Weld		
	Crushed/Crimped Burrs						Instruct	ions Incomplete/Unc	clear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	_	
	Heat T	reat			Countersink	Mislabeled				Positioned W	Vrong	
	Inspection Strip in Tube Cut Too Short						Misread	l		Power Loss/S	Surge	Other
	Ripple	in Bend			Drill Holes	Г	Offset			-		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

August-08-13 8:58:14 AM

Work Order ID: Parent Item:	105536 D3179-041						Start D	ate: 8/08/13	Required Date: 8/08/13
Parent Item Name:		WN (NON-LOCKING	i)					Qty: 2.00	Required Qty: 2.00
MS21042L3		Purchased	No		180	Each	7,418.0000	ı	2 / /
Nut									
				ation	Loc Oty		Loc Code		
			FP0	001	3				/
				122141	3				
			GA		18			-	<u></u>
				122452	18				
			ST3	314	891				<u> </u>
				111668	1				
				117885	32				
				119017	55				<u> </u>
				119075	138				<u>—</u>
				123265	43				<u> </u>
				M126036	622				
			ST:		1506				
				123900	912				
				124291	594			_&_	_ .
			SIS	510a	5000				
				M126275	1000 4000				
1000000 1 12			3.5	M126333		D1-	022 0000		01
MS27039-1-13 Screw		Purchased	No		180	Each	932.0000	1	2 E/S 13/08/20
			<u>1.00</u>	eation_	Loc Oty		Loc Code		
			GA		2				_//
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			ST3	304	30				
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											DQA:		ne.	
NCR:	⁄es	/ No				WORK ORDER NON-C	100	NFORM	AANCE / UPDA	TE	QA Closed:	Da	ıte:	
Work Orde	>r·		·,.			DISPOSITION		_	,	AGAINST DE				
Part I	۱۰۰۰				,	Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing Work Order Update Large Fab Composite					Water Je			Engineering Quality Other
Root					Descri	ption of work order update	1	nitial	Action)	Sign &			. .
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Descripti	ion	Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved					·									
			····			 ~_ _ ~	AUL	T CATE	GORY					
Landi	_	1			Γ-	General		ادسنم			Ovalized		_	Pressure/Forced
		Bending Centre No	ot Concer	ntric to (o/s	Bend BOM/Route	\vdash	Grain Hardwa	re		Over/Under	tolerance	\vdash	Temperature/Cure
		Cracks			· -	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs		Instruct	ions Incomplete/Uncl	lear	Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs	•			Contamination		Mainte		<u> </u>	Part Moved			
		Heat Trea	et.			Countersink	$oxed{oxed}$	Mislabe	led		Positioned V	· = ·		1
	$oxedsymbol{oxedsymbol{oxed}}$	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge		Other
		Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

August-08-13 8:58:14 AM

Work Order ID:

105536

Parent Item:

D3179-041

Parent Item Name:

LITTER TIE DOWN (NON-LOCKING)

NAS1149D0332J

Purchased

No

Start Date: 8/08/13

Required Date: 8/08/13

Start Qty: 2.00

Required Qty: 2.00

3

100 Washer Loc Otv Location

ST293 37 125268 37 ST294 2808 122973 106 125044 282 m125807 2420

Loc Code

2,845.0000

Each

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE	OA Classed	0-1	

											QA CIO	osed:	Da	ite:	
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part N	•					Rework Scrap Use-as-is Work Order Update		i i	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Red		Water Jet J. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	T	Initial	Act	tion	Sign	&			·
Cause]	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desci	ription	Dat	te	Verification	n	QC Inspector
Doc/Data						· · -									
Equip/Tooling														1	
Operator															
Material) <u> </u>								l			
Setup]												
Other	Ш		İ								1				
Process	Щ											1			
Supplier												ı		-	
Training												1			
Unapproved			<u> </u>	(*									
			·		· - ·-		AUL	T CATE	GORY						
Landi	ng (1			_	General		1	•	_	_			_	
	Ш	Bending				Bend	_	Grain		<u> </u>	Ovalize			\blacksquare	Pressure/Forced
		Centre N	ot Conce	ntric to C)/5	BOM/Route	<u> </u>	Hardwa		ļ	-		tolerance	\blacksquare	Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	<u> </u>	4	ion Incomplete	<u> </u>	Part In			\vdash	Weld
	\vdash	Crushed/	'Crimped		_	Burrs	_	4	tions Incomplete/	Unclear	Part Lo		ssing	Ш	Wrong Stock Pulled
		Cuffs				Contamination		4	enance	<u> </u>	Part M				
	Heat Treat			Countersink		Mislabe		<u> </u>	Positioned Wrong						
		Inspectio		Tube	L	Cut Too Short	_	Misrea	d	L	Power	Loss/S	urge	Ш	Other
	L	Ripples in			<u> </u>	Drill Holes		Offset							
•	_	Torque V			·	Drawing	_	4	Calibration			***			·
	L	Turning S	Sequence			Finish		Out of	Sequence						
Ì	Wave/Twist in Tube			1	Folio		Outside	Dimensions							

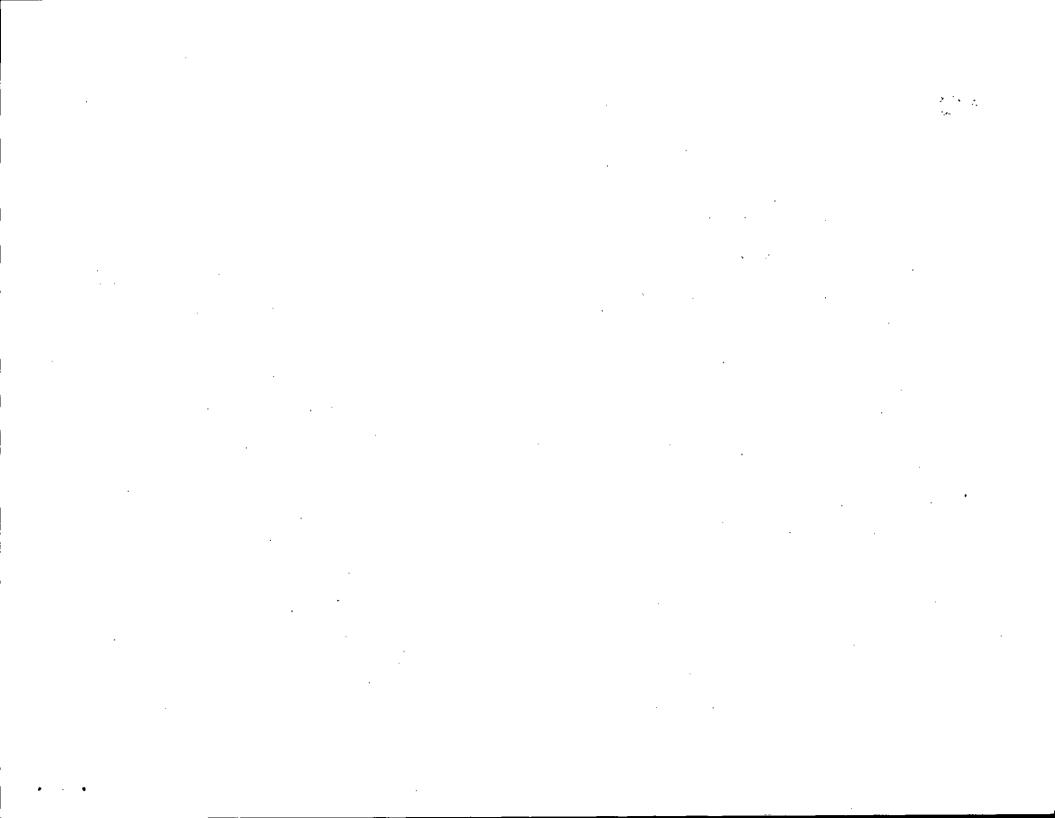
DART AEROSPACE LTD	Work Order:	105536
Description: Fwd Litter Tie Down Bracket	Part Number:	D3179-1
Inspection Dwg: D3179 Rev: D		Page 1 of 1

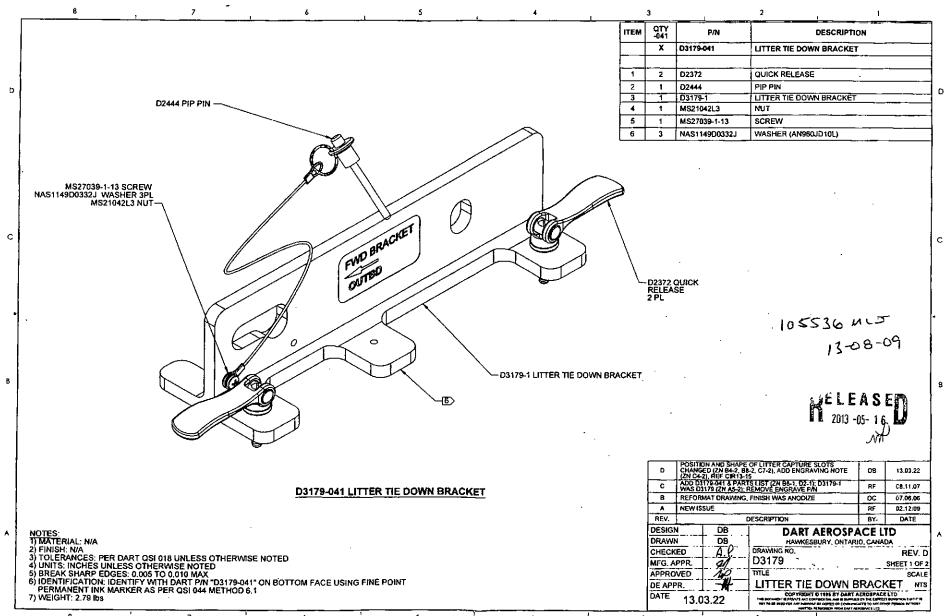
FIRST ARTICLE INSPECTION CHECKLIST

Dimension	Tolerance	Actual Dimension	.Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.004			De05	("ULTEN
Ø0.242	+0.005/-0.001	.242		,		Din Comer
R0.40	+/-0.030	R.40				RADIUS GMAT.
0.375	+/-0.010	385			Deas	Veren 6"
Ø0.191	+0.005/-0.001	.191				DIN GALL
1.00	+/-0.030	1.001			Dros	6"vern
1.70	+/-0.030	1.697			1	
4.00	+/-0.030	4.002				
1.50	+/-0.030	1.498				
0.750	+/-0.010	,751				
1.50	+/-0.030	1.50				
10.500	+/-0.010	10.5			DE 00	12" VERN.
4.250	+/-0.010	4.250			De us	15" voen
0.750	+/-0.010	.749			1	
1.000	+/-0.010	1.001			t	(*
12.00	+/-0.030	12.005			DR 08	12" LENN.
1.00	+/-0.030	.999			DR OF	6" vcHPN
8.00	+/-0.030	8.00				<u> </u>
Ø0.191	+0.005/-0.001	.198				Probable.
R0.37	+/-0.030	.37				Projus Gonet
1.875	+/-0.010	1.873			DROG	6"VERN
0.375	+/-0.010	.377				
2.125	+/-0.010	2.127				
1.250	+/-0.010	1.252				
1.00	+/-0.030	.978				
3.31	+/-0.030	334				
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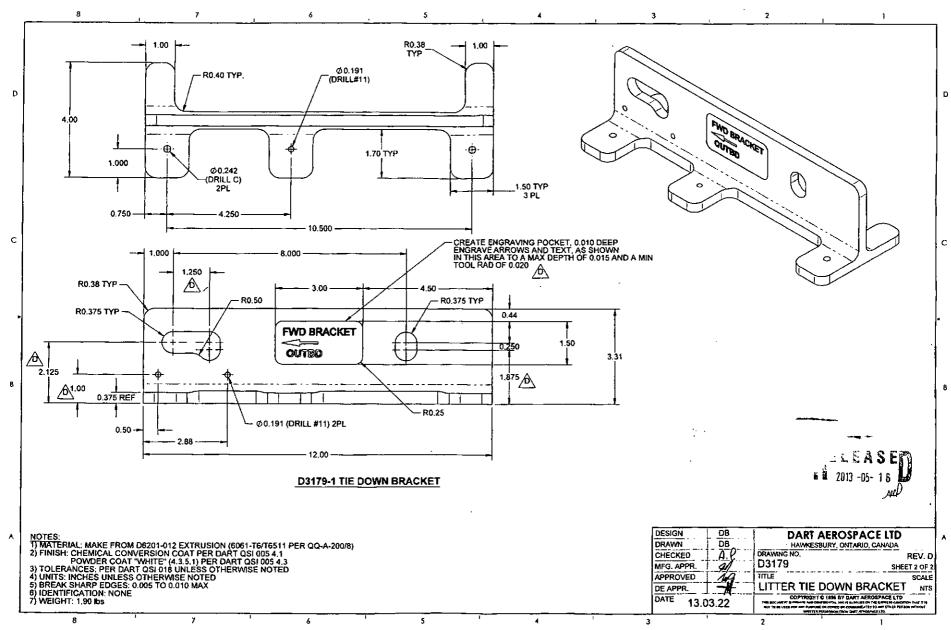
Measured by: DR./ 1	Audited by:	SL	Preliminary Approval:	
Date: 13/04/16	Date:	13-73-19	Date:	

Rev	Date	Change	Revised by	Approved
Α	09.04.05	New Issue P/O D3179-041	KJ/DD	
В	12.10.04	Dimension 0.750 was 1.750	KJ IN	
С	13.05.27	Dimensions revised per Dwg Rev D	KJ +	





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